

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007674**Date Inspected:** 10-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Japan Steel Works**Location:** Muroran, Japan

<b>CWI Name:</b>	Pin-Tang Hsu		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Component:</b>	Tower, Jacking and Deviation Saddles		

**Bridge No:** 34-0006**Summary of Items Observed:**

On this date, 7/10/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and associated built up plate sections in the Fabrication shop #4 at Japan Steel Works (JSW), Muroran, Japan.

**WEST DEVIATION SADDLES**

W2W1 - This QA Inspector observed the cast portion having had grid lines mapping out the casting in preparation for 100% Wet MT by the NDT personnel from the Foundry. Located in Fabrication Shop #4.

W2W3 - Welder Y. Maeyama 94-5234, is FCAW welding lifting lugs to ends of saddle casting at locations previously buttered, the process was passed down to D. Kito of second shift, when, the monitoring of the weld parameters were then being performed by QC CWI Mr. Pin-Tang Hsu. The built up plate portion has returned to Fabrication shop #4.

**TOWER SADDLES**

T1-2 - Stiffeners are welded and contour grinding is in process to profile the welds.

T1-3 - Base plate, 9-4, was being welded by three individuals, M. Kubota 74-3666, R. Iizuka 06-2643 and M. Kashiwada 08-2008, joints in progress were 9Y-12L-2, 9Y-12L-2 and 9Y-12L-3 respectively. Procedure in use was SJ-3012-3, FCAW, 1.6mm TM55 weld wire, in Fabrication Shop #4. These functions were being monitored by QC CWI Mr. Chung Fu Kuan on a random basis. Second Shift personnel assuming the processes of these

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joints were K.Kobayashi 08-5023 and Y.Watanabe 73-3873 welding joints 9Y-12L-2 and 9Y-12L-3 respectively. The duties of monitoring the parameters continued with CWI Mr. Pin-Tang Hsu.

EAST SADDLES and WEST JACKING SADDLE - On this day, QA Inspector Mike Brcic observed no work being performed in Foundry, apparent shut down for evening (time was 1620 local time, Japan).

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

### Summary of Conversations:

No significant conversations to report on this day.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Brcic,Michael	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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